

Split.

Date: Friday, 10/5/2007 11:02:12 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, LH, 206  
 Job Number : 35046 - /  
 Estimate Number : 10818  
 P.O. Number :  
 This Issue : 10/5/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D26651  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2665 REV.D  
 Previous Run : 33090 Drawing Revision : D  
 Material :  
 Due Date : 10/22/2007 Qty: 63 Um: Each  
 Written By :  
 Checked & Approved By : 10/07/10/05  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house  
 processEC  
 Est Rev:D As per Rev D 07-03-19 JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6101003

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch no. B34873

SF 08/02/06

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on N/A by ---

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

NTO

SF 08/02/06

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SF 08/02/06

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/02/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2665-1 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: D Date: 08/02/14  
 QA: N/C Closed: 14 Date: 08/02/14

NCR: 35046		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/07	2.0	4 parts; dim. L (0.110) was too low (0.060)  R.C. Humman 22007	1 08/02/12	Raised Origine and tool #17  Scrap all four (Qty 4)  and replace B4 34813	08/02/07 DTP	08/02/11	08/02/12	08/02/11

NOTE: Date & initial all entries

Friday, 10/5/2007 11:02:12 AM  
Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 35046

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/02/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-02-12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/02/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-02-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

8/2/13 50 (6x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/2/14 (6)

Job Completion



min 2008/2/13 (6)

W

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 35046
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

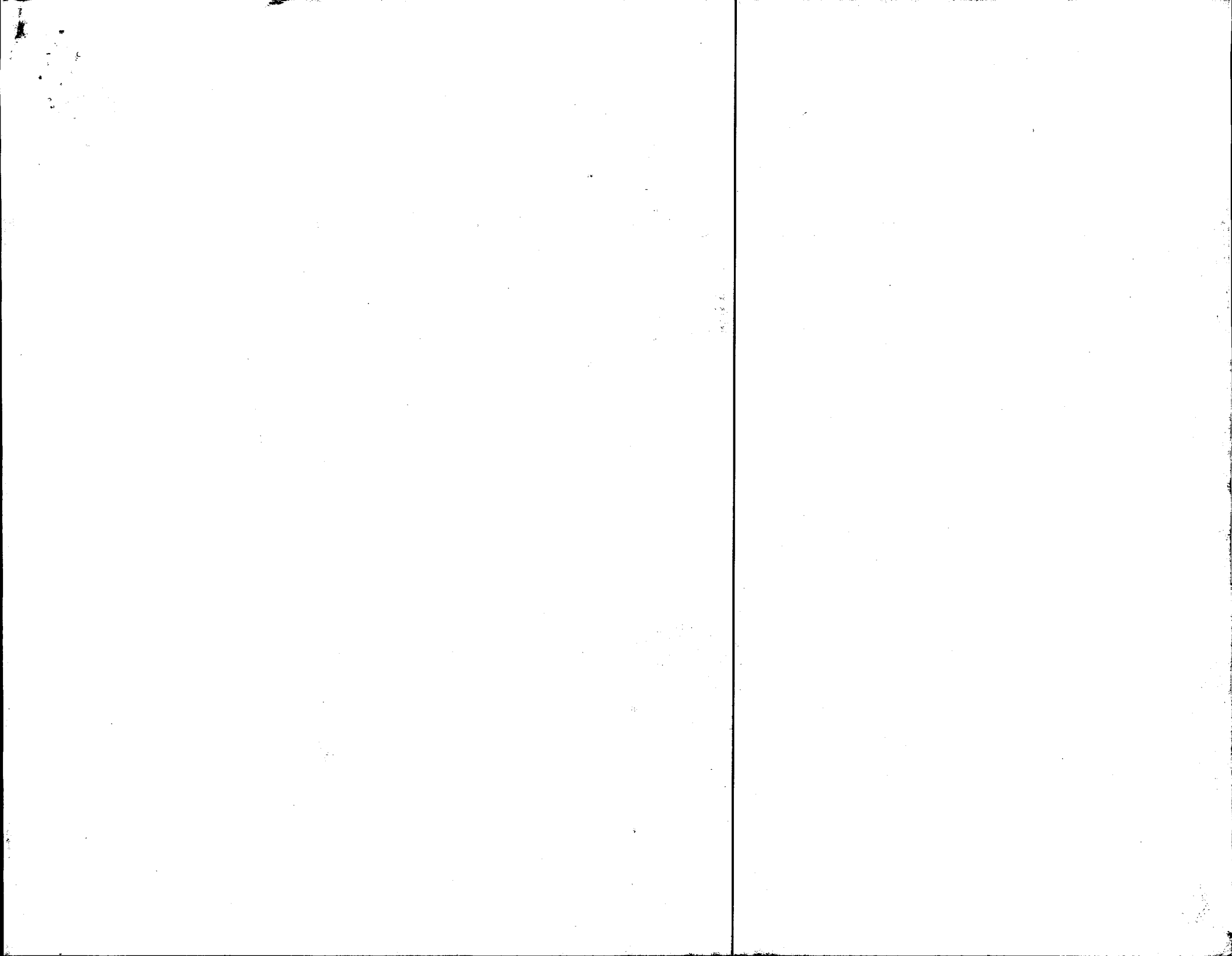
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.127	.127			
B	0.100	0.140		.136	.136	.136			
C	1.125	1.145		1.135	1.135	1.135			
D	0.615	0.685		.650	.650	.650			
E	0.240	0.260		.259	.259	.259			
F	1.313	1.343		1.328	1.328	1.328			
G	0.210	0.230		.222	.225	.226			
H	0.100	0.180		.141	.140	.140			
I	2.470	2.510		2.493	2.495	2.495			
J	1.565	1.585		1.575	1.575	1.575			
K	0.235	0.240		.240	.251	.251			
L	0.100	0.120		.124	.114	.114			
M	0.990	1.010		1.010	1.010	1.010			
N	0.510	0.515		.510	.510	.510			
O	5.990	6.010		5.999	6.000	6.000			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.503	2.500	2.500			
R	0.313	0.318		.313	.313	.313			
S	0.315	0.322		.318	.318	.318			
T	2.495	2.505		2.499	2.499	2.500			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		.801	.801	.801			
W	0.540	0.560		.546	.545	.545			
X	1.674	1.684		1.679	1.678	1.678			
Y	0.257	0.262		.258	.258	.258			
Z	0.912	0.932		.927	.927	.927			
AA	0.490	0.510		.503	.503	.503			
AB	0.178	0.198		.188	.188	.188			
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>LF</u>
Date: <u>08/02/06</u>

Audited by: <u>J.L</u>
Date: <u>08/02/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 35046
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.130	0.129	.130	.130		
B	0.100	0.140		0.133	0.133	.133	.133		
C	1.125	1.145		1.140	1.140	0.140	1.1375		
D	0.615	0.685		0.670	0.670	.670	.670		
E	0.240	0.260		0.255	0.254	.254	.254		
F	1.313	1.343		1.321	0.321	1.321	1.321		
G	0.210	0.230		0.223	0.222	.222	.222		
H	0.100	0.180		0.140	0.140	.140	.140		
I	2.470	2.510		2.494	2.492	2.492	2.492		
J	1.565	1.585		1.580	1.580	1.580	1.5775		
K	0.235	0.240		0.238	0.238	.238	.238		
L	0.100	0.120		0.116	0.116	.116	.116		
M	0.990	1.010		1.004	1.005	1.005	1.005		
N	0.510	0.515		0.511	0.511	.511	.511		
O	5.990	6.010		6.003	6.003	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.50	2.50	2.50	2.50		
R	0.313	0.318		0.314	0.314	.314	.314		
S	0.315	0.322		0.320	0.320	.320	.320		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.361	1.3615	1.361	1.361		
V	0.787	0.807		0.796	0.800	.800	.800		
W	0.540	0.560		0.546	0.547	.547	.547		
X	1.674	1.684		1.678	1.678	1.678	1.678		
Y	0.257	0.262		0.259	0.259	.259	.259		
Z	0.912	0.932		0.923	0.923	.923	.923		
AA	0.490	0.510		0.4985	0.499	.499	.499		
AB	0.178	0.198		0.186	0.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DSF</u>
Date: <u>08/02/08</u>

Audited by: <u>SL</u>
Date: <u>08/02/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	35046
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2665-1
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	3	4	By	Date
A	0.100	0.140		.130	.130				
B	0.100	0.140		.133	.133				
C	1.125	1.145		1.1375	1.137				
D	0.615	0.685		.670	.670				
E	0.240	0.260		.254	.254				
F	1.313	1.343		1.321	1.321				
G	0.210	0.230		.222	.222				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.492	2.492				
J	1.565	1.585		1.575	1.575				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.110	.110				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515		.511	.511				
O	5.990	6.010		6.002	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.318	.318				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.360	1.360				
V	0.787	0.807		.800	.800				
W	0.540	0.560		.550	.550				
X	1.674	1.684		1.680	1.680				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.922	.922				
AA	0.490	0.510		.500	.500				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.P.
Date:	08/02/11

Audited by:	J.L.
Date:	08/02/11

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B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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